

ABSTRACT

The invention relates to a method for forming at least one flat-tube insertion slot in a header tube. A sawcut is introduced into the header tube during a sawing step, and the slot is configured, during a subsequent punching step, by means of a slot punch, which punches into the region of the sawcut. A rimmed opening can be configured during the punching step by using a slot punch with a larger width and/or length relative to the sawcut. The sawcut is preferably introduced to a depth less than the wall thickness of the header tube. The respective web region(s) between chamber of a multi-chamber header tube can be compressed during the punching operation to a level lower than that of a header-tube wall region functioning as a flat-tube insertion stop, in order to form a chamber-connecting duct.